



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 200578



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	10/7/19	10/7/19	0.00	0.00	Packaging 1 - 1		OCT 07 2019
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
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							Packaging 1 - 19		
							Packaging 1 - 20		
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							Packaging 1 - 22		
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							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Container No: S222254



Part: 646.4001

Job No: 200578

Serial No/Batch: S222254

Revision:

Inspector:

Exp Date: 03/13/2020

Instructions: FAA STC SR02180LA 14/04/07 TC SH09 -

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120 QC 4	1 pcs	10/7/19	0.00 0.00	Packaging 1 - 31		
				Packaging 1 - 32		
				Packaging 1 - 33		
				Packaging 1 - 34		
				Packaging 1 - 35		
				Packaging 1 - 36		
				QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
130 Packaging 3-1 - Stock - B4B	1 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
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				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
135 DC - 1 - B4B	1 pcs	10/7/19	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B		
140 QC 21 - FG	1 pcs	10/7/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - FG - 53		

Part Op 110 - pick kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP 646.4001 Location:

DAS
78
9-89

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OCT 23 2019

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OCT 23 2019

DAS
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OCT 23 2019

DAS
21
9-89

OCT 23 2019

Part Op 110 - pick kit
 Descriptions: 120 - QC4- 100% Inspect kits for completeness
 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____

135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5215003
600.0993	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5182078
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5182079
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5215116
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5106242
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5195161
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5207983 5182509
646.3110	Channel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192931
646.3210	Support	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5171298
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5208793
646.3510	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5187254
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183035
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5172257
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5059684
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183057
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5183061
646.3713	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5190438
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5197814
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5190147
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5172198
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5190396
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5202529
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5202485
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5190891
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5196402
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5193559
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5193553
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5218108
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5185806
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5208530
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5185683
646.3910	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5204465
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5187902
650.920	Eyelet Bracket Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5175957
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5214902
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5166926
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5098032
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5203253
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5167263
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149158
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149185
AN31804R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5198106
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5163586
AN407A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5142044
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5203154
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5156961
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5181023 5185286 5214471 10
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	7157848
MS20470AD5-5-5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5155675
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048893
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5123405
MS21042L06	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5205000
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5204283
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5214467
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5203289
MS24693-C276	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5202672

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MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5133343
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5185070
MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5142492
MS27039-08-11	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5123437
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5154310
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5154310
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5157063
MS27039-1-18	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5216386
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5182772
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5167994X3 5171793X1
NAS1149F0332P	Washer (AN960-10L)	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	5207709
NAS1149F0383P	Washer (AN960-10)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5075330
NAS1149F0432P	Washer (AN960-416L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5214714
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5191300

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	263	0
	600.0990	1	15	0
	600.0991	1	14	0
	600.1012	1	11	0
	600.1013	5	35	0
	646.2910	1	11	0
	646.3001	1	11	0
	646.3110	1	17	0
	646.3210	1	11	0
	646.3301	1	11	0
	646.3510	1	21	0
	646.3511	1	20	0
	646.3610	1	14	0
	646.3710	1	27	0
	646.3711	1	13	0
	646.3712	1	17	0
	646.3713	1	17	0
	646.3714	1	20	0
	646.3715	2	17	0
	646.3716	1	31	0
	646.3717	1	26	0
	646.3718	2	31	0
	646.3719	2	12	0
	646.3810	2	21	0
	646.3811	1	21	0
	646.3812	2	14	0
	646.3813	1	27	0
	646.3910	4	16	0
	646.3911	1	18	0
	646.3912	4	22	0
	646.3913	1	14	0
	646.9410	1	51	0
	647.0112	2	30	0
	647.7703	2	16	0
	650.9201	2	11	0
	AN3-11A	10	151	0
	AN3-12A	2	146	0
	AN3-13A	1	29	0
	AN3-3A	4	187	0
	AN3-4A	10	281	0
	AN3-5A	2	38	0
	AN3-6A	2	288	0
	AN316C4R	2	28	0
	AN44-5A	2	21	0
	AN4C7A	2	67	0
	AN665-34R	2	32	0
	CCR264SS3-02	36	280	0
	CR3213-5-3	14	46	0
	MS20426AD5-7	2	671	0
	MS20470AD5-5-5	8	777	0
	MS20470AD5-6	8	614	0
	MS20470AD5-7	3	1,026	0

MS21042L08	2	964	0
MS21042L3	63	1,950	0
MS21042L4	2	1,490	0
MS21047-3	18	176	0
MS24693-C278	5	101	0
MS24694-S51	5	257	0
MS24694-S54	2	146	0
MS24694-S55	3	201	0
MS27039-08-13	2	355	0
MS27039-1-10	2	242	0
MS27039-1-12	6	130	0
MS27039-1-16	24	620	0
MS27039-1-19	22	205	0
MS27039-1-20	2	58	0
MS27039-1-21	4	119	0
NAS1149F0332P	144	2,000	0
NAS1149F0363P	2	352	0
NAS1149F0432P	4	318	0
NAS1149FN832P	4	2,159	0

Part Specifications

Specifications could not be found.

Plex 9/12/19 1:24 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐				Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																																									
Description Work Order Deviation												Disposition																																			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐												FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐												Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐												Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐											
												Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐												Other/Details: _____																							
												Completed By _____												Lead hand / Supervisor _____												QC / QA Coordinator _____											

NOTES:
 1. AFTER INSTALLATION, APPLY FIN 54 A/R TO RILL GAPS AND RILL ETGES.
 2. INSTALL FIN 14 WITH FIN 52 & 53.
 3. 3M VHB ALUMINUM TAPE 1/2" THICK 1/2" WIDE
 4. 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
 5. VENDOR: R.S. HUGHES P/N 021200-27214.
 6. REUSE FASTENERS FROM P/N 1.
 7. USE WASHERS A/R AS SHOWN TO OBTAIN BEST FITMENT.
 8. AT CUSTOMER'S OPTION, INSTALL FIN 68 BY MATCH DRILLING CH TO FIN 1.
 9. INSTALL SHIM IF OEM PROVIDES AS APPLICABLE ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT FIT. MATCH DRILL HOLES. USE FIN 78 SCREW IN PLACE OF FIN 17 SCREW.
 10. NEWEL INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE FIN 62 TO REPLACE FIN 44 & FIN 26 IN PLACE OF FIN 41 WHEN NECESSARY.

UNINCORPORATED ROW(S)

REF	QTY	UNIT	DESCRIPTION	PART #	FIN #	DATE	SPEC.
1	1	1	SCREW	601.3875			
2	1	1	SHIM	646.3910			
3	1	1	WASHER	601.2764			
4	1	1	LOCKNUT	601.2977			
5	1	1	SCREW	601.2988			
6	1	1	LOCKNUT	601.2943			
7	1	1	WASHER	601.3728			
8	1	1	LOCKNUT	601.3209			
9	1	1	WASHER	601.2636			
10	1	1	BOLT	601.2669			
11	1	1	EYE BOLT	601.3121			
12	1	1	EYE BOLT	601.3121			
13	1	1	EYE BOLT	601.3121			
14	1	1	EYE BOLT	601.3121			
15	1	1	EYE BOLT	601.3121			
16	1	1	EYE BOLT	601.3121			
17	1	1	EYE BOLT	601.3121			
18	1	1	EYE BOLT	601.3121			
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69	1	1	EYE BOLT	601.3121			
70	1	1	EYE BOLT	601.3121			
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96	1	1	EYE BOLT	601.3121			
97	1	1	EYE BOLT	601.3121			
98	1	1	EYE BOLT	601.3121			
99	1	1	EYE BOLT	601.3121			
100	1	1	EYE BOLT	601.3121			

REV	QTY	UNIT	DESCRIPTION	PART #	FIN #	DATE	SPEC.
1	2	2	SCREW	601.2879			
2	2	2	SCREW	601.2831			
3	2	2	SCREW	601.2831			
4	2	2	SCREW	601.2831			
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DATE: 10/10/00
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DATE: 10/10/00
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